

Date: Thursday, 10/18/2007 8:00:01 AM  
 User: Kim Johnston

## Process Sheet

47

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : LONG STEP ASSEMBLY HIGH SKID RH  
 Job Number : 35195  
 Estimate Number : 10274  
 P.O. Number : N/A Part Number : D350591312  
 This Issue : 10/18/2007 S.O. No. : N/A Drawing Number : D3272 REV B  
 Prsht Rev. : NC Project Number : N/A  
 First Issue : N/A Type : LARGE FAB ASSY Drawing Revision : B  
 Previous Run : 35069 Material : N/A  
 Due Date : 11/20/2007 Qty: 10 Um: Each  
 Written By :  
 Checked & Approved By : 10.10.18  
 Comment : Est Rev:A 04.03.22 New issue KJ/RF  
 Est Rev:B 07-06-09 Added D3572-1 JLM

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Photocopy bluefile and type labels as per PPP D350-591-312 CHG001

Handwritten signature and date: 10/11/2007

2.0 D32721 STEP



Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)

STEP

BATCH: 3 34950

Handwritten signature and date: 10/11/2007

3.0 D30671 End Plate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)

Pick:

Qty Part Number Description Batch  
 1 D3067-1 End Plate 835079

Handwritten signature and date: 10/11/2007

4.0 D32191 Support



Comment: Qty.: 2.0000 Each(s)/Unit Total : 20.0000 Each(s)

Pick:

Qty Part Number Description Batch  
 2 D3219-1 Support 835080

Handwritten signature and date: 10/11/2007

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Thursday, 10/18/2007 8:00:01 AM  
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LONG STEP ASSEMBLY HIGH SKID RH

Job Number: 35195

Part Number: D350591312

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Bevel end for welding FWD ONLY

2-Weld Support using Jig DT8719, weld Fwd End Plate as per QSI 004 & Dwg D3272

A/R Aluminum Rod M105138  
M105844

3-Grind End Plate flush

*PH 07-11-12 10*

*PH 07-11-12 10*

*SAD 07-11-13 (10)*

6.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

*PD 07-11-13 (10)*

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

*Fail 10 (10)*  
*RH*

8.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

*M. 10X*  
*07/11/14*

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

*PH 07-11-15 10*

10.0

D3065041

Step Leg Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total: 10.0000 Each(s)

Pick:

Qty Part Number Description Batch  
1 D3065-041 Step Leg Assy 333510

*PH 07-11-15 10*

11.0

D30661

Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total: 20.0000 Each(s)

Pick:

Qty Part Number Description Batch  
2 D3066-1 Spacer 334467

*PH 07-11-15 10*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Thursday, 10/18/2007 8:00:02 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LONG STEP ASSEMBLY HIGH SKID RH

Job Number: 35195

Part Number: D350591312

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

MS20600AD4W4

Rivets



Comment: Qty.: 16.0000 Each(s)/Unit Total : 160.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

16 MS20600AD4W4

Rivet

*M105792*

*Pl 07-11-15 10*

13.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Assemble Leg Assembly as per Dwg D3272.

*Pl 07-11-15 10*

14.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

*M 07/11/15 @*

15.0

D30671

End Plate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D3067-1

End Plate

*335079*

*Pl 07-11-15 10*

16.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Bevel Aft end for welding

2-Inspect for foreign object as per QSI 024

3-Weld Aft End Plate as per QSI 004 & Dwg D3272

A/R Aluminum Rod *M105058*

4-Grind End Plate flush

5-Install last rivet.

*Pl 07-11-15 10*  
*Pl 07-11-15 10*  
*Pl 07-11-15 10*  
*SAD 07-11-17 (10)*  
*Q.M. 07-11-19 10*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Thursday, 10/18/2007 8:00:02 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LONG STEP ASSEMBLY HIGH SKID RH

Job Number: 35195

Part Number: D350591312

Job Number:



Seq. #:

Machine Or Operation:

Description :

17.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

07-11-19 (10)

18.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

07-11-19 (10)

19.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Touch up Alodine

MS 07-11-19

X10 RH

20.0

POWDER COATING

POWDER COATING



M105914



10X RH

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

M-1/19

07/11/19

21.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



M106030



P10

Comment: HAND FINISHING RESOURCE #1

Wing Walk as per Dwg D3272 and QSI 005 4.4

MS/19

07/11/20

(10)

22.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: Inspect Powder Coat and Wing Walk

7/11/20

50 (10)

23.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

7/11/20

(10X)

50

24.0

D22303

Mounting Lug



Comment: Qty.: 4.0000 Each(s)/Unit Total: 40.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

4 D2230-3 Mounting Lug

B35013

MS 07/11/20 (10X)

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D350-591-312 PAR #: N/A Fault Category: Prod/Finishing NCR: Yes No DQA: 2D Date: 07/11/22  
 QA: N/C Closed: KG Date: 07.11.23

NCR: 35195		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/11/20	21.0	one step D350-591-312 has not enough Powder coat covering the surface of the step. R.C. Human error	OS1012	Sculd the entire <del>surface</del> <sup>step</sup> with 320 grit sand paper.	M-11 07/11/20	[Signature] 07/11/22	OS1012	07/11/20
				Re Powder as per QS2005	M-11 07/11/20			
				Re Apply wing wall/c as per QS2005.	FJ 07/11/20			

NOTE: Date & initial all entries



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Drawing Name: LONG STEP ASSEMBLY HIGH SKID RH

Job Number: 35195

Part Number: D350591312

Job Number:



Seq. #:

Machine Or Operation:

Description :

25.0

D2618

Bushing



Comment: Qty.: 2.0000 Each(s)/Unit Total : 20.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

2 D2618

Bushing

B33991

AS 07/11/20 (10x)

26.0

D2856400

Abrasion Strip



Comment: Qty.: 0.6000 f(s)/Unit Total : 6.0000 f(s)

Pick: Packing Kit

Qty Part Number Description Batch

2 D2856-400-720 Abrasion Strip

B34642

AS 07/11/20 (10x)

27.0

D32351

Mounting Lug



Comment: Qty.: 2.0000 Each(s)/Unit Total : 20.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

2 D3235-1

Mounting Lug

B30996

AS 07/11/20 (10x)

28.0

D3278041

Support Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

1 D3278-041

Support Assembly

B35893

AS 07/11/21 (10)

29.0

AN335A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 20.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

2 AN3-35A

Bolt

B105408

AS 07/11/20 (10x)

30.0

AN413A

Bolt



Comment: Qty.: 8.0000 Each(s)/Unit Total : 80.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

8 AN4-13A

Bolt

B105906

AS 07/11/20 (10x)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Drawing Name: LONG STEP ASSEMBLY HIGH SKID RH

Job Number: 35195

Part Number: D350591312

Job Number:



Seq. #:

Machine Or Operation:

Description :

31.0

AN536A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 20.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

2 AN5-36A

Bolt

B105953

KS 07/11/20

(10x)

32.0

AN960JD10

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 40.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

4 AN960JD10

Washer

M105792

KS 07/11/20

(10x)

33.0

AN960JD416

Washer



Comment: Qty.: 16.0000 Each(s)/Unit Total : 160.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

16 AN960JD416

Washer

M105426

KS 07/11/20

(10x)

34.0

AN960JD516

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 40.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

4 AN960JD516

Washer

M104156

KS 07/11/20

(10x)

35.0

MS21042L3

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total : 20.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

2 MS21042L3

Nut (or -3)

M104625

KS 07/11/20

(10x)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 10/18/2007 8:00:02 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LONG STEP ASSEMBLY HIGH SKID RH

Job Number: 35195

Part Number: D350591312

Job Number:



Seq. #:

Machine Or Operation:

Description :

36.0

MS21042L4

Nut

|||||



Comment: Qty.: 8.0000 Each(s)/Unit Total : 80.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

8 MS21042L4

Nut (or -4)

M105054

KS 07/11/20

(10x)

37.0

MS21042L5

Nut

|||||



Comment: Qty.: 2.0000 Each(s)/Unit Total : 20.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

2 MS21042L5

Nut (or -5)

M105430

KS 07/11/20

(10x)

38.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

KS 07/11/21 10KITS

39.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D350-591-312

Location:

15

7/11/21 (10x)

SP

40.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

KS 07/11/22

Job Completion



u 07.11.21

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

**DART**

DESIGN <i>qp</i>	DRAWN BY <i>B</i>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>LE</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3272	REV. B SHEET 1 OF 3
DATE 07.05.18		TITLE STEP ASSEMBLY, HI LONG	SCALE NTS
A	04.03.01	NEW ISSUE	
B	07.05.18	D3272-1 WAS D2622-120	

**RELEASED**07.06.04 *[Signature]*

QTY -041	QTY -042	PART NUMBER	DESCRIPTION
X		D3272-041	STEP ASSEMBLY, HIGH LONG (LH)
	X	D3272-042	STEP ASSEMBLY, HIGH LONG (RH)
1	1	D3065-041	LEG ASSEMBLY
2	2	D3066-1	SPACER
2	2	D3067-1	END PLATE
2	2	D3219-1	SUPPORT
1	1	D3272-1	STEP
16	16	MS20600AD4W4	RIVET

**GENERAL NOTES:**

- 1) D3272-041 SHOWN. FOR D3272-042, INSTALL D3219-1 SUPPORT OPPOSITE SIDE
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005.4.1  
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3  
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED.
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX.

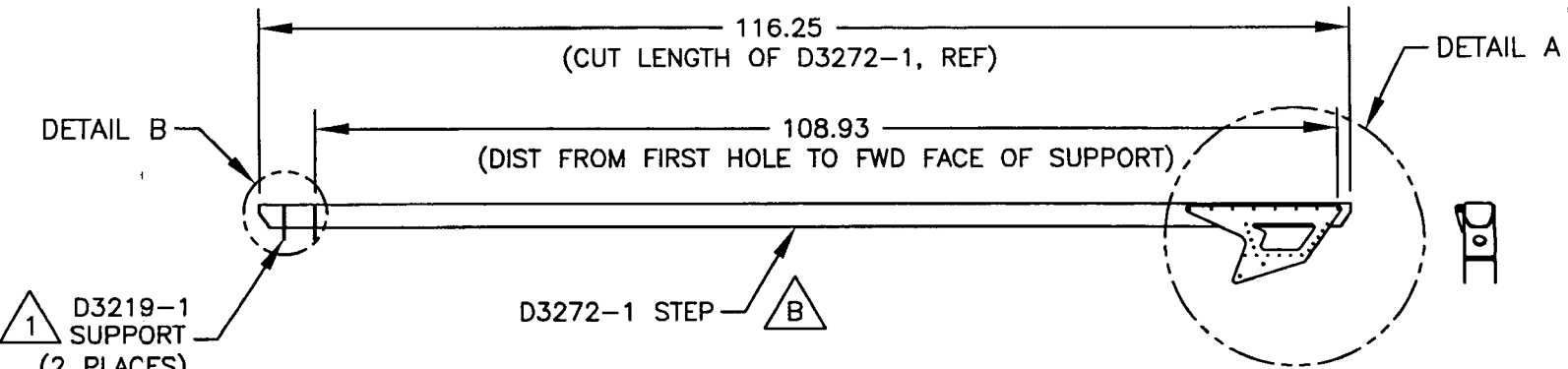
SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. *35195*

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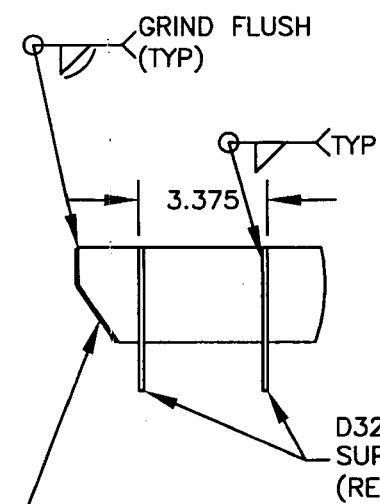
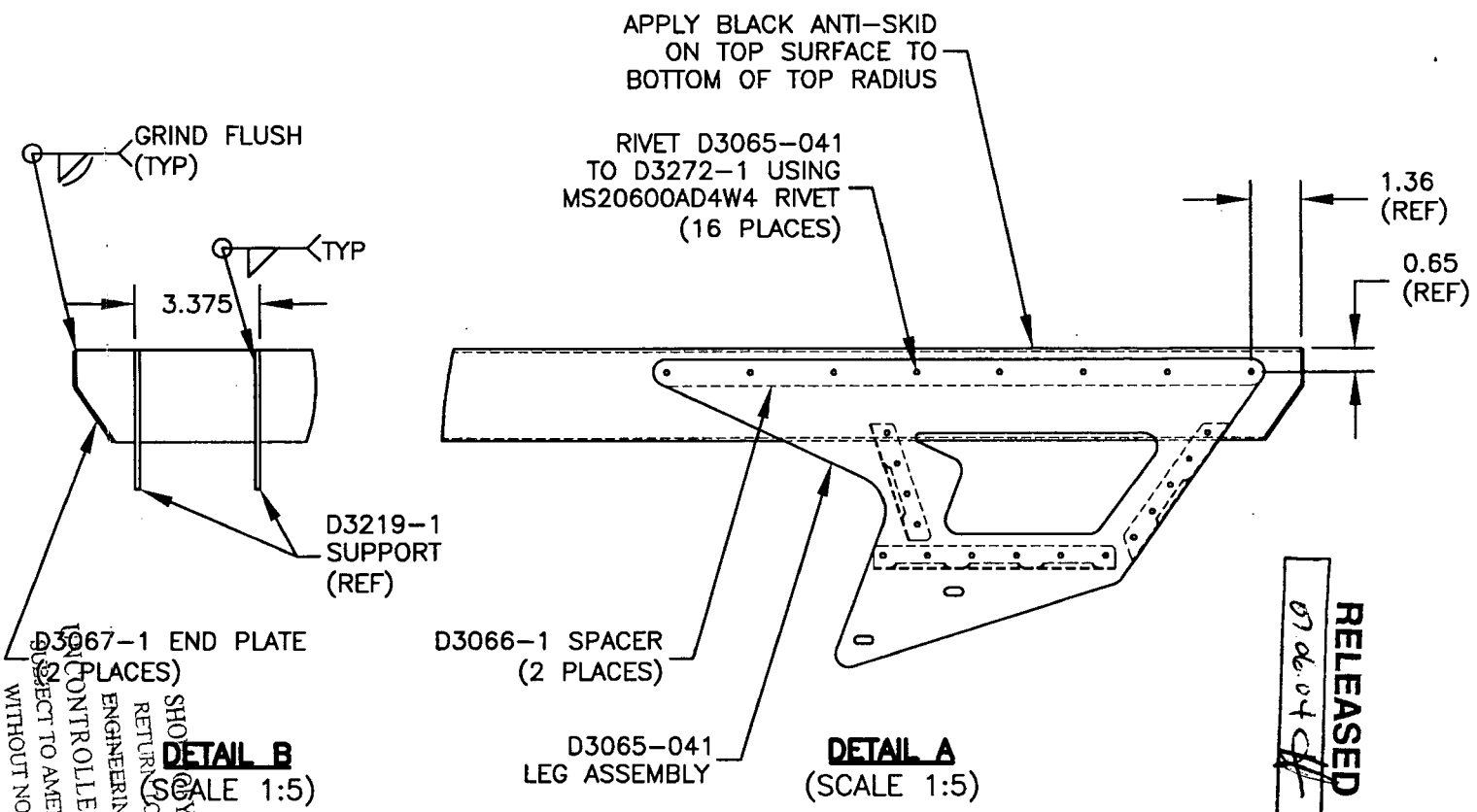
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DESIGN	90	DRAWN BY	90	DART AEROSPACE LTD HAWESBURY, ONTARIO, CANADA	REV. B
CHECKED	CE	APPROVED	CE	DRAWING NO. D3272	SHEET 2 OF 3
DATE	07.05.18	TITLE	STEP ASSEMBLY, HI LONG	SCALE	1:20



**D3272-041 STEP ASSEMBLY (LH. SHOWN)**  
D3272-042 STEP ASSEMBLY (RH, OPPOSITE)



**DETAIL B**  
(SCALE 1:5)

D3067-1 END PLATE (2 PLACES)  
CONTROLLED COPY  
ENGINEERING  
RETURN TO  
SHO  
Y  
NO  
WORK ORDER  
35195  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE

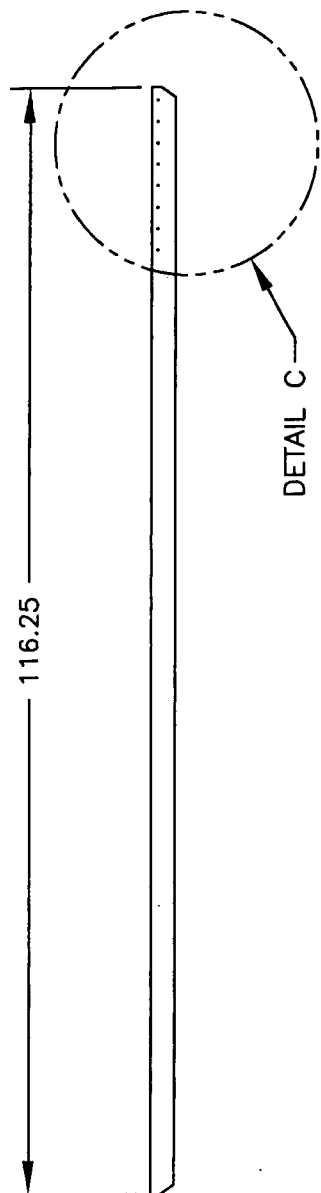




DESIGN <i>GP</i>	DRAWN BY <i>JB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>LE</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3272	REV. B SHEET 3 OF 3
DATE 07.05.18		TITLE STEP ASSEMBLY, HI LONG	SCALE 1:20

RELEASED

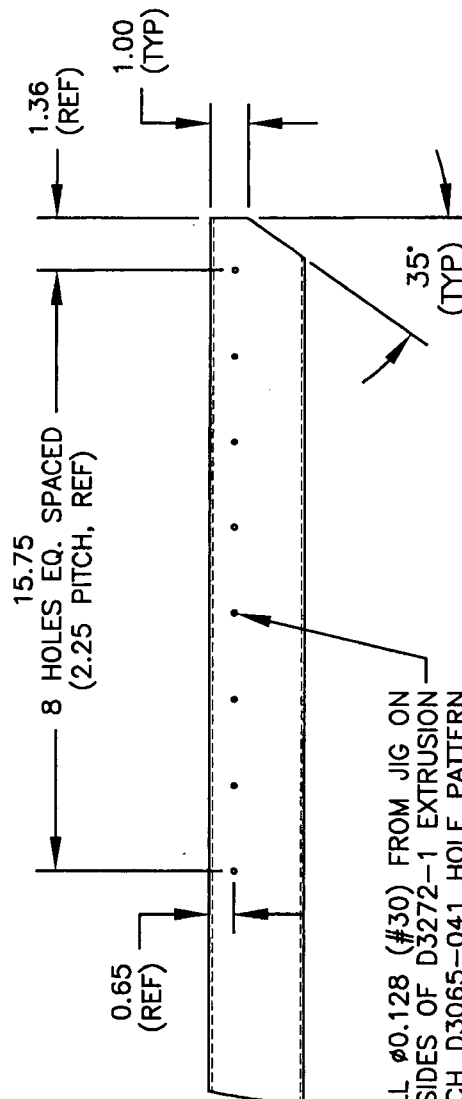
07.06.04 *[Signature]*



DETAIL C

**B D3272-1 STEP**

(MAKE FROM D2622-120 STEP EXTRUSION)



DRILL  $\phi 0.128$  (#30) FROM JIG ON  
BOTH SIDES OF D3272-1 EXTRUSION  
TO MATCH D3065-041 HOLE PATTERN

**DETAIL C**  
(SCALE 1:5)

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 35195

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User: Kim Johnston

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Job Number	:	35195			
Estimate Number	:	10274			
P.O. Number	:		Part Number	:	D350591312
This Issue	:	10/18/2007 S.O. No. :	Drawing Number	:	D3272 REV B
Prsht Rev.	:	NC	Project Number	:	N/A
First Issue	:	// Type : LARGE FAB ASSY	Drawing Revision	:	B
Previous Run	:	35069	Material	:	
Written By	:	<u>JJ 07.10.18</u>	Due Date	:	11/20/2007 Qty: 10 Um: Each
Checked & Approved By	:	<u>JJ 07.10.18</u>			
Comment	:	Est Rev:A 04.03.22 New issue KJ/RF			
		Est Rev:B 07-06-09 Added D3572-1 JLM			

### Additional Product

Job Number: 

Seq. #:	Machine Or Operation:	Description :
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1.0 DC DOCUMENT CONTROL



**Comment:** DOCUMENT CONTROL

Photocopy bluefile and type labels as per PPP D350-591-312 CHG001

07.10.22

2.0	D32721	STEP
-----	--------	------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)

## STEP

BATCH:

3.0	D30671	End Plate
-----	--------	-----------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
-----	-------------	-------------	-------

1 D3067-1 End Plate \_\_\_\_\_

4.0 D32191 Support

Comment: Qty.: 2.0000 Each(s)/Unit Total: 20.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch

2 D3219-1 Support \_\_\_\_\_

**REFERENCE ONLY**